

Work Order ID 50247

July 14, 2009 10:39:25 AM



Page 1

Item ID: D3238-33

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-07-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3238	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3238 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary ☐ ***Use cutting file D3238-21-23-25*****

M-f 09/09/30

B 9-9-29

(Q1X)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8/07/01/30

(+21)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50247

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Page 2

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Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

[Signature]

09/09/30

(21)

[Signature]

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD

09-09-30

(21)

Quality Control

150

Identify as per dwg & Stock Location: 76

0.00



Packaging

Memo

0.00

09/09/30

(21)

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50247

July 14, 2009 10:39:25 AM



Page 3

Item ID: D3238-33

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/30/01 *[Signature]*

MF 09-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 10:39:25 AM

Page 1

Work Order ID: 50247

Parent Item: D3238-33RevC

Parent Item Name: Plate




Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.020		Purchased	No			100	sf	0.0000	0.2526			
												
6061-T6 Sheet .020												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

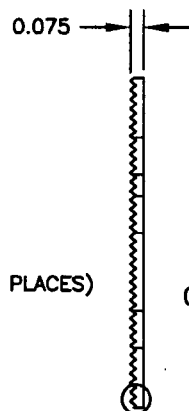
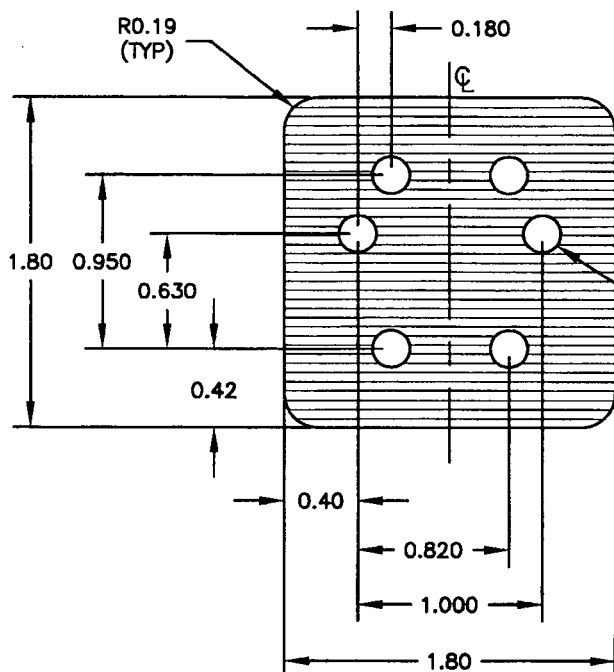
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



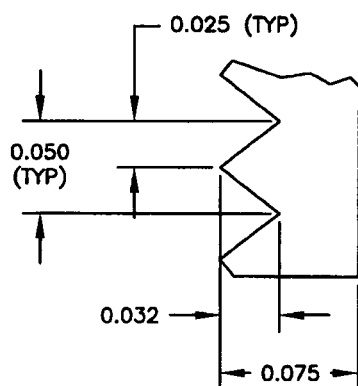
RELEASED

07.02.20 #

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

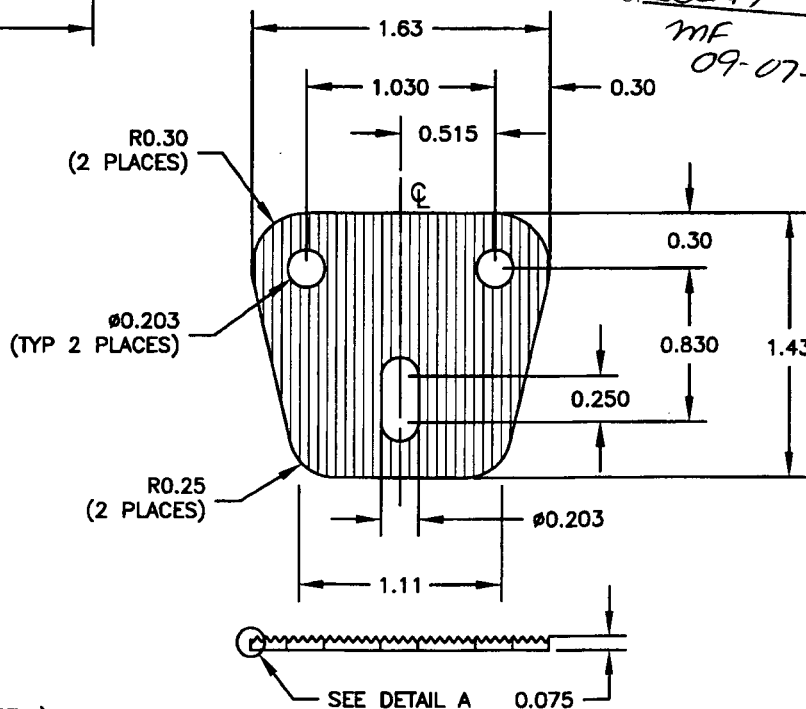
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50247

MF
09-07-15



DETAIL A

RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)

D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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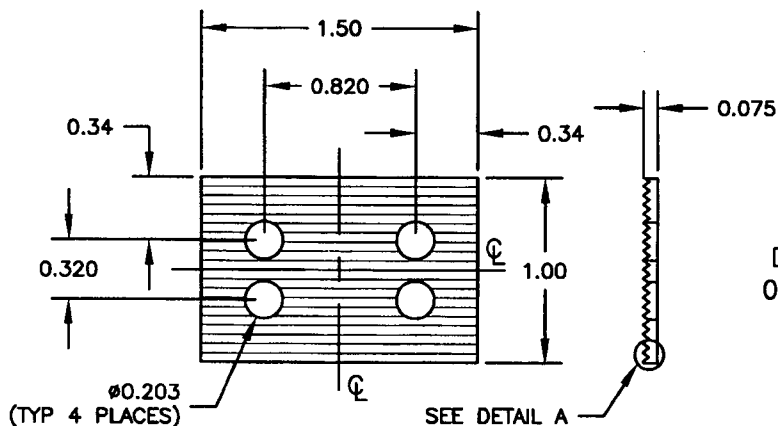
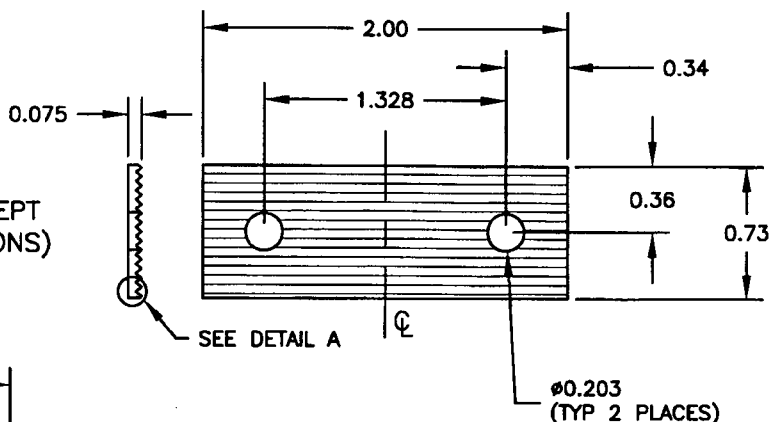
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DART

DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20 [Signature]

D3238-1 PLATE (SHOWN)D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

AMS 4037-50247

MF
09-07-15**NOTES:**

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037-50247
(REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
ORALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) SEE SHEET 3 FOR DETAIL A

7) PARTS ARE SYMMETRIC ABOUT ϕ

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